

Date: Friday, 30/11/2007 2:38:06 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM	
Job Number	: 36089		Part Number	: D2845	
Estimate Number	: 11668		Drawing Number	: D2845 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 30/11/2007 S.O. No. : N/A		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 07/12/2007	
Previous Run	:		Qty:	6	
Written By	:		Um:	Each	
Checked & Approved By	:				
Comment	: Est: B 00.11.01 Removed P/O for Powder Coat - in house processEC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TRO500W035	304 RD Tube .500 x .035W
Comment: Qty.: 1.6109 f(s)/Unit Total : 9.6655 f(s) 304 RD Tube .500 x .035W M304TRO500W035 Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 17.11" long (Hole ctr. to hole ctr.) using Jig DT 8012 Batch M106015		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Form per Dwg D2845 using brake andbending Jig DT 8238-C Deburr →		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
4.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3		
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/01/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST226

AS

08/01/08

KS

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 08/01/08
(3)

Job Completion



u 08/01/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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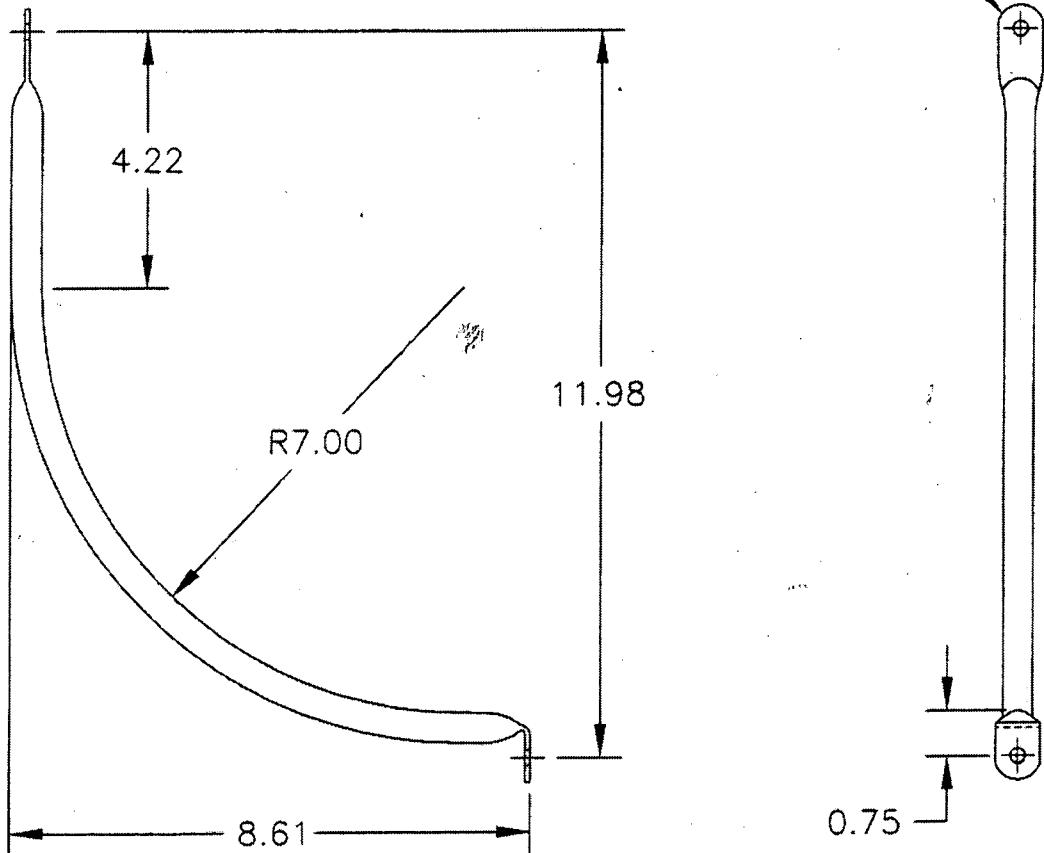
NOTE: Date & initial all entries

DART

DESIGN <i>RE</i>	DRAWN BY <i>RE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>PH</i>	APPROVED <i>JS</i>	DRAWING NO. D2845
DATE 98.10.14		REV. A SHEET 1 OF 1 TITLE ARM SCALE 1:3
A	98.10.14	NEW ISSUE

RELEASED
16.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries